

Work Order ID 73747

Wednesday, September 14, 2011 11:19:27 A



Page 1

Item ID: D2892-1

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 9/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/19/2011 Req'd Qty: 4.00



Customer:

Reference: REWORK

Approvals:

Process Plan: *MF*

Date: *11-09-14*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2892	B

190 0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

PULL FROM STOCK D2892-1 X 4
B34063
STRIP OFF EXISTING PAINT

MF 11 09 27 (4)

200 0.00



QC

QC3- Inspect Part Finish

Memo

0.00

Quality Control

IS 11 09 27 (4)

210 0.00



HandFinish

Memo

0.00

Hand Finishing

Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and
apply 3M Scotch-Weld as per dwg.
24H of cure time.

W 11 09 27 (4)

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Customer:

Reference: REWORK

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

18 11-09-28 (4)

230

0.00



QC

Memo

0.00

Quality Control

N/A

240

Identify as per dwg & Stock Location: X-tube

0.00



Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER

ASS'y

11 09 28 (4)

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Customer:

Reference: REWORK

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

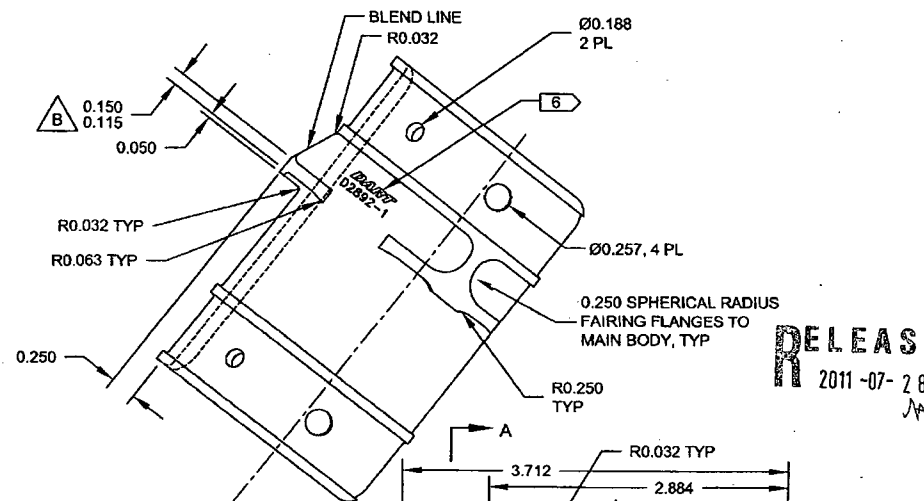
0.00

Quality Control

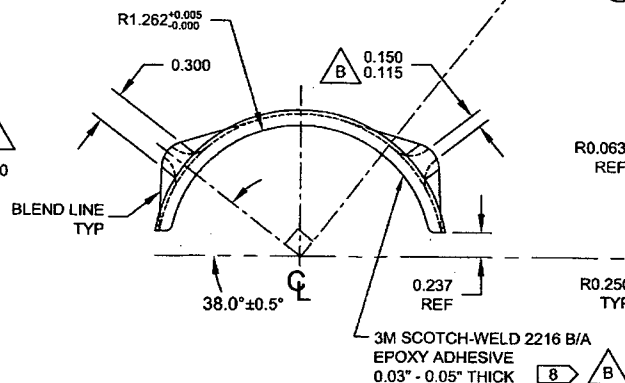
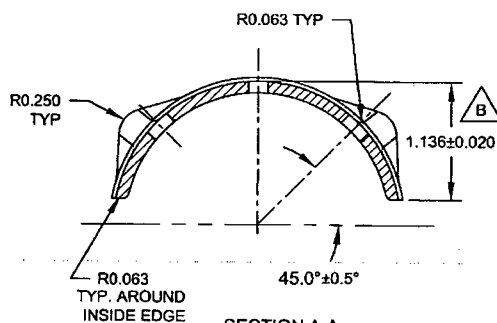
11/9/28 [Signature]
MF
11-09-28

NOTES:

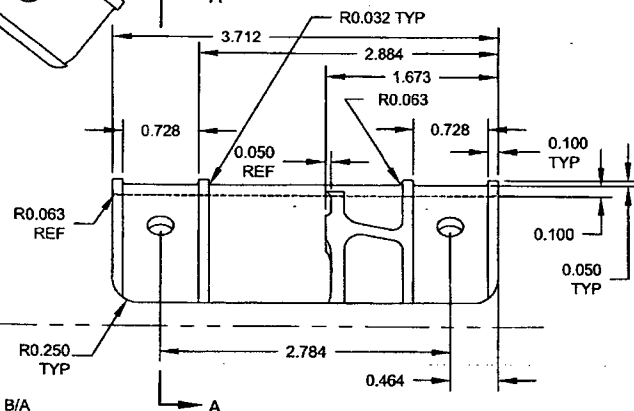
- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.41 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIV. LENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



RELEASED
R 2011-07-28



D2892-1 SUPPORT



B	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION, UPDATE TOLERANCE (ZN D5-1,B5-1,B6-1)	CP	11.07.15
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	P		
DRAWN	P		
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		
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